



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2939-2

Job Sheet 179301



Part No: D2939-2

Job Qty: 4 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Machining-1		SB 18/08/01
100	CNC Vertical Machining	4 pcs	6/29/18	6/29/18	0.00	3.74	HAAS1-2		11/18 18/08/03
110	Mill Conv	4 pcs	6/29/18	6/29/18	0.00	0.20	Mill Conv 1		18 18-08-03
120	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC21		18 18-08-03
130	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-1		momt 18/08/04
140	HandFinish	4 pcs	6/29/18	6/29/18	0.00	0.10	HandFinish1		D.R 18-08-09
150	Powdercoat	4 pcs	6/29/18	6/29/18	0.00	0.13	Powdercoat1		AL 18-08-13
160	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC3		18-08-13
170	Packaging	4 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1		57395
180	QC21-SA	4 Ea	6/29/18	6/29/18	0.00	0.00	QC21		AUG 16 2018

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA021.

150 - START TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	5011637 + 5098393

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	77	0

Part Specifications

Specifications could not be found.



Container No: S098394



Part: D2939-2

Job No: 179301

Serial No/Batch: S098394

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/01/18

DART AEROSPACE LTD		Work Order: 179301
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.119	0.125	0.127	0.128	
B	0.100	0.140		.118	0.126	0.126	0.127	
C	0.100	0.140		.112	0.112	0.116		
D	0.210	0.230		.226	0.227	0.227	0.227	
E	1.245	1.255		1.250	1.25	1.25	1.25	
F	1.245	1.255		1.250	1.250	1.25	1.25	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		0.502	0.510	0.511	0.511	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.508	2.500	2.500	
K	0.257	0.262		.257	0.257	0.257	.257	
L	0.312	0.317		.312	0.312	0.312	0.312	
M	0.235	0.240		.237	0.237	0.237	0.237	
N	0.100	0.140		.126	0.127	0.127	0.126	
O	0.540	0.560		.548	0.550	0.551	0.548	
P	0.490	0.510		.502	0.503	0.504	0.502	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.492	2.492	2.492	2.492	
S	0.240	0.270		.255	0.256	0.255	0.255	
T	0.100	0.180		.127	0.127	0.127	0.127	
U	1.625	1.635		1.630	1.620	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.637	1.637	
W	0.316	0.321		.316	0.316	0.316	0.316	
X	1.250	1.270		1.260	1.280	1.260	1.260	
Y	1.565	1.585		1.575	1.575	1.575	1.575	
Z	0.178	0.198		.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:		Date:	
Audited by: <i>mmk</i>		Date: 18/08/09	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

DQA: _____ Date: _____

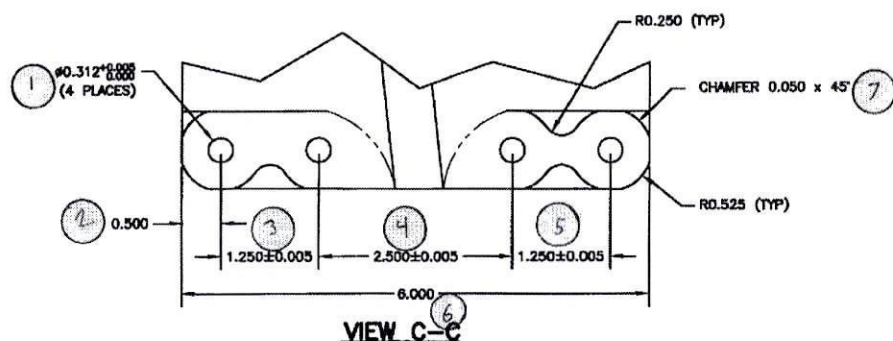


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

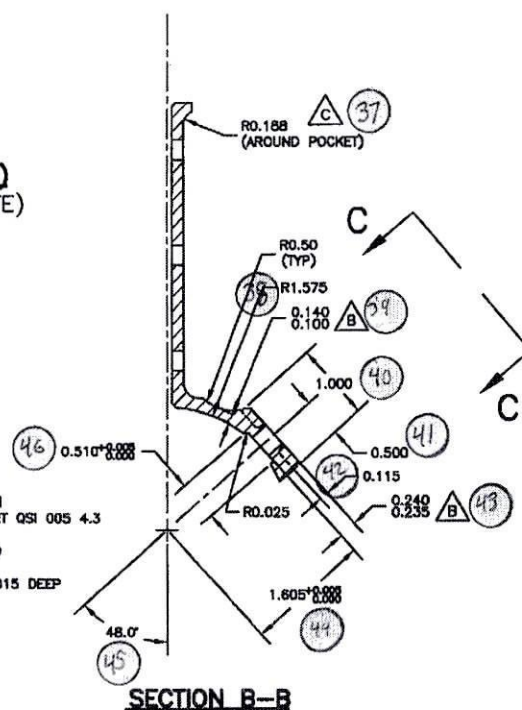
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

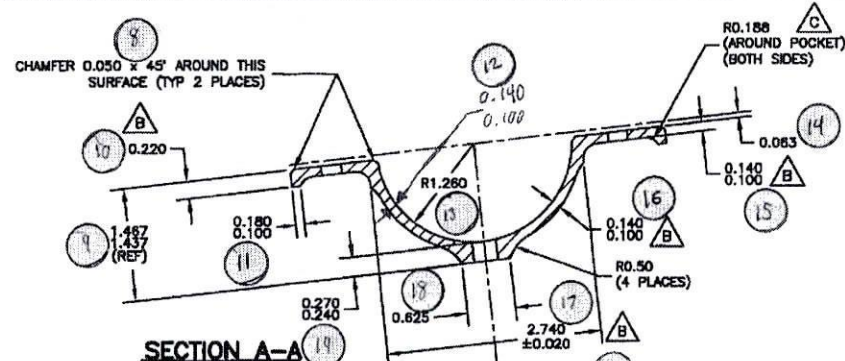


D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

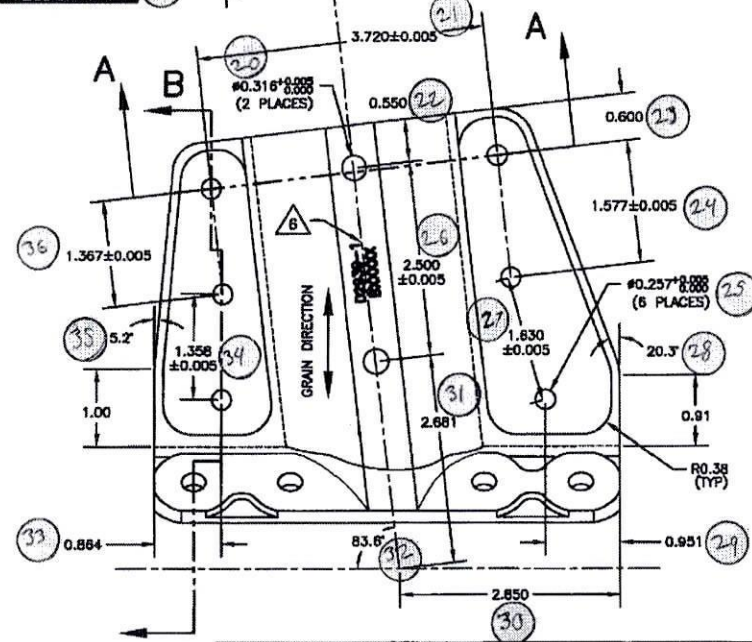
- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (00-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA
DRAWING NO. D2939
SHEET 1 OF 1
SCALE
2:3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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